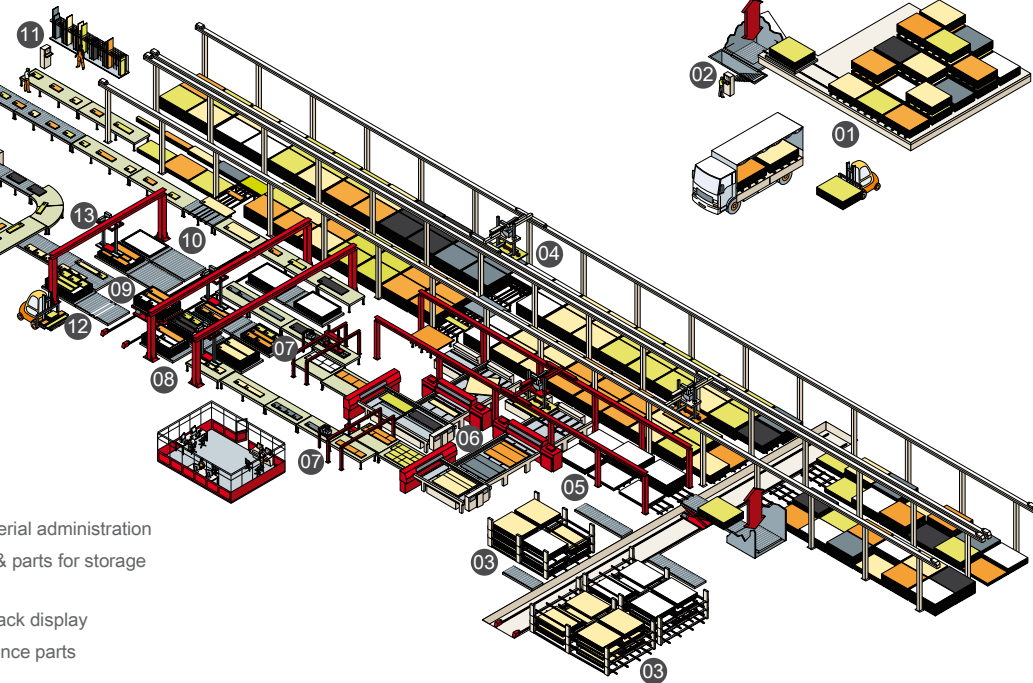
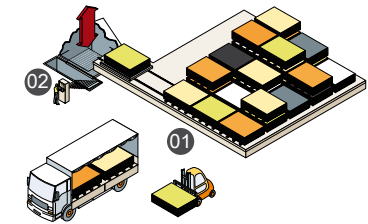


# MES technology with 3Tec

## Office furniture production, processing and sorting in batch size 1

- ▶ Up to 6000 parts per shift
- ▶ Edgebanding by **IMA** Klessmann
- ▶ Storage, logistics, conveyors and sorting units by **IMA** Meinert
- ▶ Angular saw by **schelling**
- ▶ Size of finished parts: 230 x 120 up to 2800 x 1500 mm

- 01 Incoming goods with intermediate buffer
- 02 Preparation of stacks for A and B/C storage
- 03 A material stack storage
- 04 B/C material storage (sorted and/or chaotic) including reusable boards
- 05 Infeed for saws with space for preparation of A material
- 06 Angular saw
- 07 Routing decision point including labelling
- 08 Loading of parts in trays
- 09 Buffer before edgebanding
- 10 Return of reusable boards
- 11 Manual storage of reusable boards
- 12 Special parts stacked on pallets
- 13 Edgebander infeed
- 14 Single-sided edgebander
- 15 Edgebander preview and edge material administration
- 16 Separation of commissioned parts & parts for storage
- 17 Automatic stacking unit
- 18 Hedgehog with exact destination stack display
- 19 Buffer storage with sorting to sequence parts correctly for assembly



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**3TEC**

# MES technology with 3Tec

## Office furniture production, processing and sorting in batch size 1

- **Automatic high-bay rack storage for A material**
- **Automatic floor storage for B/C material and reusable boards**
- **2 angular saws with optimized layout of parts for the crosscut saw**
- **Labelling of component parts**
- **Intermediate buffer for edgebanding**
- **4 single-sided edgebanders**
- **Automatic stacking unit for stock parts**
- **Automatic sorting unit for commissioned parts**

### Production data import and preparation

- All data relevant to production is imported from the ERP system
- Feedback to SAP system
- Production data stored in Oracle database
- Planning of production jobs and optimization of cutting plans
- Data preparation for edgebanding
- Edgebander preview and edge material administration
- Handling of re-productions and quick shots

### Control system

#### Processing of incoming goods

- Import orders from SAP
- Incoming goods feedback to SAP

#### Warehouse management and control

- Automatic floor storage of raw and reusable boards
- Automatic high-bay rack storage for A material
- Manual storage of reusable boards

#### Material flow control

- Tracking of individual parts
- Connections to production machines
- Labelling
- Monitoring via barcode scanning

#### System-wide display elements

- Control of display elements at hedgehog for exact destination stack display
- Operator guidance
- Diagnostics and error recovery